

Work Order ID 85836-1

June-15-12 1:35:07 PM

85836

Page 1

Item ID: D2939-1

Revision ID:

Item Name: Saddle LH In. 206

Start Date: 15/06/2012 Start Qty: 600

Required Date: 29/06/2012 Req'd Qty: 600

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: ML

QC:

Date: 12/06/15

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00

100

HAAS I

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00

110

Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00

120

QC

QC1- Inspect dimensions to dimension sheet

Memo

0.00

Quality Control

RT 12-07-18 (x9)
P10

RT 12-07-18 (x9)

RT 12-07-18 (x9)

W/O: 85836		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Proc Mgr	Approval QC Inspector

Part No: D2935-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: Full Date: 12/07/27
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: OK Date: 12/7/27

NCR: 12-11621		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-07-17	100	@ skid bolt location before machining keyway are side measures .272 other side measures .219 part wasn't sitting properly	<u>12/07/17</u> <u>PS1042</u>	scrap & replace <u>B 81923</u> (x1) D6101-001	<u>RT</u> <u>12-07-17</u>	<u>Full</u> <u>12-07-17</u> <u>PS1042</u>	<u>Full</u> <u>12/07/17</u> <u>PS1042</u>	<u>DAS</u> <u>16</u> <u>PS</u>
12-07-17	100	RC operator error offset on T4 set too low base .010" over tolerance wall thickness is @ min operator error	<u>12/07/17</u> <u>PS1042</u>	Scrap Destroy Qty 4 Part will cause increased stress fracture when installed. Replace <u>SCRAP</u> <u>9/2/07/18</u> <u>Replace B 81923</u>	<u>RT</u> <u>12-07-18</u>		<u>Full</u> <u>12-07-17</u> <u>PS1042</u>	<u>DAS</u> <u>16</u> <u>PS</u>
12-07-17	100	offset on T11 too low cut chamfer too deep around crossbolt islands RC operator error		Scrap & Destroy Qty x1 D6101-001 <u>B 81923</u>	<u>RT</u> <u>12-07-17</u>			<u>DAS</u> <u>16</u> <u>PS</u>

NOTE: Date & initial all entries

Work Order ID 85836

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Item ID: D2939-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle LH In. 206

Start Date: 15/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

12 7 19 9 3

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

9 12 7 19

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

12-20

11-50

9X 12/07/19

m121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85836

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Item ID: D2939-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle LH In. 206

Start Date: 15/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

9 0 12-7-19

170

Identify as per dwg & Stock Location: 8745A 0.00

170

Packaging

Memo

0.00

Packaging

9x

12-7-24.

180

QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

12/7/24

mf 12-07-24.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 85836

85836

Parent Item: D2939-1

D2939-1

Parent Item Name: Saddle LH In. 206

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	97.0000	1	6			
D6101-001									**	10		12/07/06	
Saddle Billet													

Location

Loc Qty

Loc Code

MAT040

93

69677

2

76836

1

81923

50

85433

40

MAT042

4

83309

4

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action — Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 85836
Description: 206 Saddle, Inboard, Left side		Part Number: D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				4x	5x	6x	7A		
A	0.100	0.140		.117	.120	.119	.119		
B	0.100	0.140		.120	.121	.120	.121		
C	0.100	0.140		.122	.130	.130	.126		
D	0.210	0.230		.222	.225	.224	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.236	.239	.235	.238		
N	0.100	0.140		.117	.116	.116	.119		
O	0.540	0.560		.548	.549	.547	.547		
P	0.490	0.510		.498	.498	.502	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.741	2.742	2.742	2.742		
S	0.240	0.270		.256	.260	.258	.258		
T	0.100	0.180		.136	.136	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.259	1.256	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	1.574	1.569	1.570	1.574		
Z	0.178	0.198		.188	.188	.186	.186		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	RS
Date:	12-07-18

Audited by:	RF
Date:	12-7-19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	85836
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	8	9	10	4	By	Date
A	0.100	0.140		.117	.112	.119			
B	0.100	0.140		.123	.120	.119			
C	0.100	0.140		.119	.126	.128			
D	0.210	0.230		.224	.224	.223			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.512	.512	.512			
I	1.572	1.582		1.577	1.577	1.577			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.258	.258	.258			
L	0.312	0.317		.314	.314	.314			
M	0.235	0.240		.238	.238	.238			
N	0.100	0.140		.116	.116	.117			
O	0.540	0.560		.549	.550	.548			
P	0.490	0.510		.500	.500	.500			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.720	2.760		2.740	2.740	2.740			
S	0.240	0.270		.256	.255	.255			
T	0.100	0.180		.137	.138	.136			
U	1.625	1.635		1.625	1.625	1.625			
V	1.362	1.372		1.362	1.362	1.362			
W	0.316	0.321		.316	.316	.316			
X	1.250	1.270		1.258	1.258	1.261			
Y	1.565	1.585	DT8695 A/B	1.571	1.573	1.580			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	PT
Date:	12-07-18

Audited by:	RF
Date:	12.7.19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 85836
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

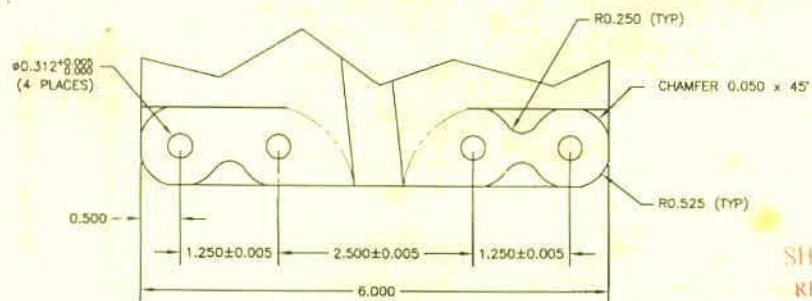
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	1/2	2/3	3/4	By	Date
A	0.100	0.140			.120	.118	.120		
B	0.100	0.140			.122	.121	.120		
C	0.100	0.140			.118	.123	.118		
D	0.210	0.230			.222	.226	.222		
E	1.245	1.255			1.250	1.248	1.252		
F	1.245	1.255			1.249	1.250	1.252		
G	2.495	2.505			2.500	2.500	2.500		
H	0.510	0.515			.511	.511	.511		
I	1.572	1.582			1.578	1.578	1.578		
J	2.495	2.505			2.500	2.500	2.500		
K	0.257	0.262			.257	.258	.258		
L	0.312	0.317			.314	.314	.314		
M	0.235	0.240			.235	.235	.235		
N	0.100	0.140			.116	.117	.117		
O	0.540	0.560			.546	.546	.548		
P	0.490	0.510			.499	.498	.500		
Q	3.715	3.725			3.716	3.718	3.716		
R	2.720	2.760			2.741	2.739	2.742		
S	0.240	0.270			.258	.257	.255		
T	0.100	0.180			.133	.136	.133		
U	1.625	1.635			1.628	1.629	1.628		
V	1.362	1.372			1.365	1.368	1.367		
W	0.316	0.321			.316	.316	.316		
X	1.250	1.270		1.285	1.258	1.258	1.261		
Y	1.565	1.585	DT8695 A/B	1.598	1.579	1.574	1.573		
Z	0.178	0.198			.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: 25
Date: 12.07.17

Audited by: RF
Date: 12.7.17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

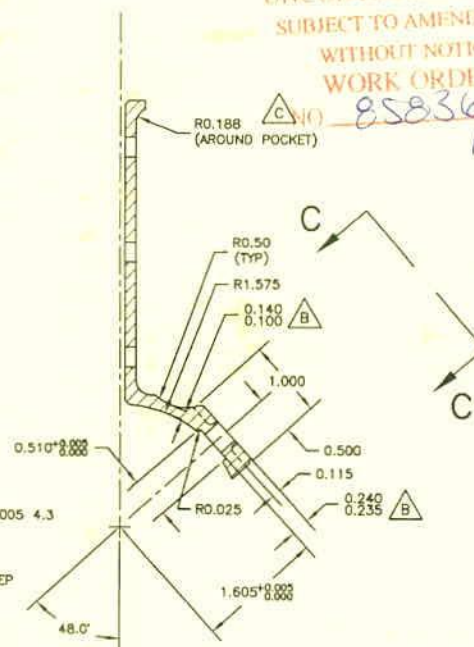


VIEW C-C

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

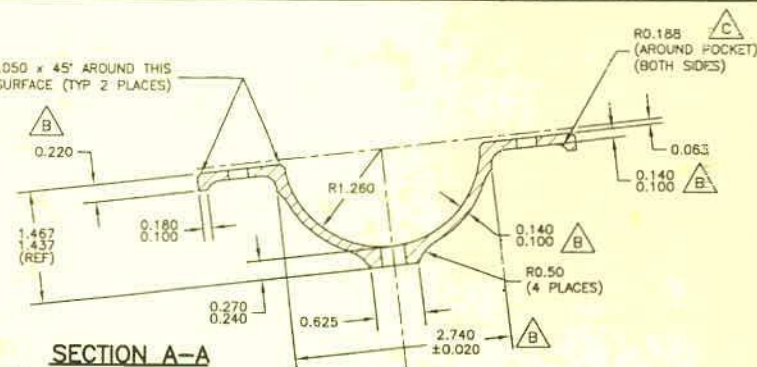
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

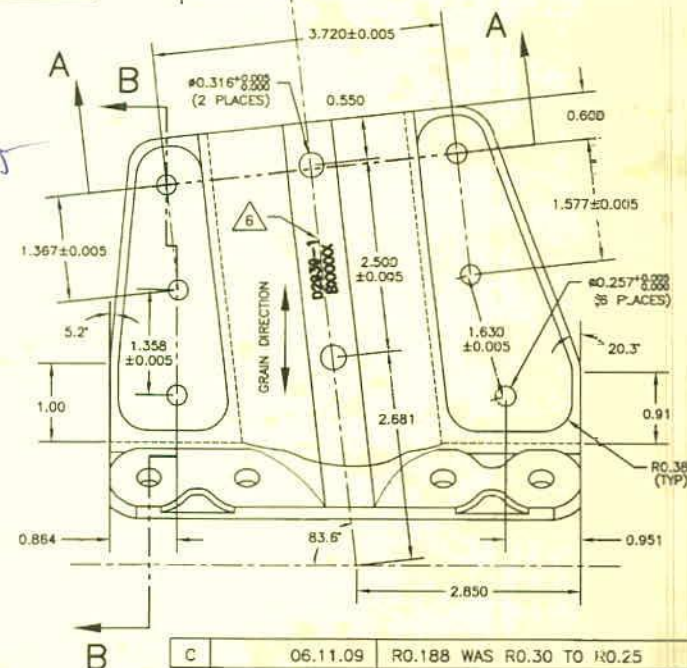


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. TOLLENE, WA
CHECKED	PH	DRAWING NO. D2939
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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01.02.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries